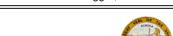
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-007943 Address: 333 Burma Road **Date Inspected:** 02-Jul-2009

City: Oakland, CA 94607

Project Name: SAS Superstructure **OSM Arrival Time:** 645 **OSM Departure Time:** 1845 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: SUN BO CWI Present: Yes No Yes **Inspected CWI report:** N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No **Weld Procedures Followed:** Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes N/A **Delayed / Cancelled:** No

34-0006 **Bridge No: Component:** OBG COMPONENT

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection BAY#9

This QA Inspector randomly observed ZPMC welding personnel performing repair welding of fillet weld joints of DP-127-002-W1~W8 for Deck Panel DP-127-002(10AW). The personnel were observed welding in the 2F position utilizing a FCAW process. Welder is identified as 201250. The welding variables recorded by QC appeared to comply with the WPS- 345-FCAW-2G(2F)-REPAIR-1.

This QA Inspector randomly observed ZPMC welding personnel performing repair welding of fillet weld joints of DP-181-001-W1~W5 for Deck Panel DP-181-001(10AW). The personnel were observed welding in the 2F position utilizing a FCAW process. Welder is identified as 201250. The welding variables recorded by QC appeared to comply with the WPS- 345-FCAW-2G(2F)-REPAIR-1.

This QA Inspector randomly observed ZPMC welding personnel performing repair welding of fillet weld joints of DP-475-001-W1~W10 for Deck Panel DP-475-001(9CE). The personnel were observed Tack welding in the 2G position utilizing a FCAW process. Welder is identified as 059373. The welding variables recorded by QC appeared to comply with the WPS- B-T-2342-U5b(U-rib).

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Ultrasonic Testing(Phased Array)

The QA Inspector performed Phased Array Ultrasonic Testing (UT) on Orthotropic Box Girder deck plates to closed rib welds at the tack weld locations (Visual repaired area). The QA Inspector generated a field inspection UT report on this date designating areas of rejectable indications.

Panel identification number is

DP-424-001(10AE) DP-153-001(9EW)

Green Tagging

This QA inspector performed final Visual Inspection for Deck Panels which were previously accepted by ZPMC Quality Control personnel and ABF QA personnel.

The member(s) are identified as

Deck Panel No. Green Tagging No.

DP-344-002(10BE) 007837 DP-236-001(10BW) 007838 DP-101-001(10BW) 007839 007840 DP-209-001(10BW) DP-155-001(10BW) 007841

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera, Subhasis	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer